



PF 650C 2K Urethane Primer Surfer

SURFACE PREPARATION:

All substrates must be degreased and sanded. All rust must be removed.

1. Wash surface with soap and water.
2. Clean metal surfaces with PF 605 Wax & Grease Remover. Clean plastic surfaces with PF 606 Plastic Parts Cleaner. Wipe dry while the surface is still wet.
3. Completely sand surface with 180 – 220 grit paper.
4. Re-clean with PF 603 Final Wipe.
5. For maximum adhesion and corrosion resistance, treat bare metal with PF 652C or PF 654 Self Etching Primer.

MIXING DIRECTIONS:

HIGH BUILD RATIO 4:1

4 parts of Primer PF 650C

1 part of Catalyst PF 651C

MEDIUM BUILD RATIO 4:1:1

4 parts of Primer PF 650C

1 part of Catalyst PF 651C

1 part Reducer PF 682C Slow, PF 683C Medium or PF 684C Fast

Mix thoroughly between components. Stir regularly after catalyzed. Strain before spraying material.

DIRECTIONS FOR USE:

All drying times refer to shop temperature of 25°C (77°F) / 50% humidity. Allow additional drying time when optimal conditions are not reached.

SPRAY GUN AND PRESSURE

Gun Type	Fluid Tip	Air Pressure
Siphon Feed	1.6-2.0mm	40-50 psi
Gravity Feed	1.6-1.8mm	35-45 psi
HVLP	1.6-1.8mm	10 psi

Apply two to three coats. Allow 15 minutes flash time between coats. Film thickness, flash times, and temperatures will effect drying time. Maximum film thickness of this product when dried should not exceed 5 mils.

DRYING TIMES:

Flash: 15 minutes

Sanding: 4 to 6 hours

For optimal results, a final sanding with 600 grit or finer paper is recommended.

FORCE DRYING:

Purge time: 15 minutes

Bake time at 60°C (140°F): 20 minutes

RECOATING:

May be recoated after 30 minutes or upon cool down after force drying at @ 60°C (140°F) for 20 minutes. After 8 hours dry time, primer must be lightly sanded before top coating.

FISH EYE: Do not use Fish Eye eliminator in this product.

POT LIFE: 1 - 2 hours.

IMPORTANT NOTE: Some mixing bases may shorten the pot life.

CLEANING INSTRUCTIONS: Clean equipment with lacquer thinner immediately after use.

CAUTION: It is important to test the compatibility of this product with your paint system. This product is not recommended for use in temperatures below 16°C (60°F). The use below these temperatures will affect dry times and performance.